

Date: Friday, 7/21/2006 1:55:02 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM
Job Number : 28025
Estimate Number : 10346
P.O. Number : N/A Part Number : D2596
This Issue : 7/21/2006 S.O. No. : N/A Drawing Number : D2596 REV C
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : C
Previous Run : 27655 Material : N/A
Written By : See Comment Below Due Date : 7/31/2006 Qty: 12 Um: Each
Checked & Approved By : 06.07.21
Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D
M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ext'n -I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	025751

Batch

025751

25 06-08-11 (12)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Cut D2500-3-100 to length: 99.5"

25 06-08-11 (12)

2- Use Jig DT8093 to drill pilot holes #30

25 06-08-14 (12)

3- Open to 0.625" diameter using a uni-bit

25 06-08-14 (12)

4- Deburr

25 06 08 14 (12)

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

IT 06-08-14 (12)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

Pmc 06-08-14 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: SD Date: 06/08/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 28025

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD

06/08/15

Job Completion



U 06/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

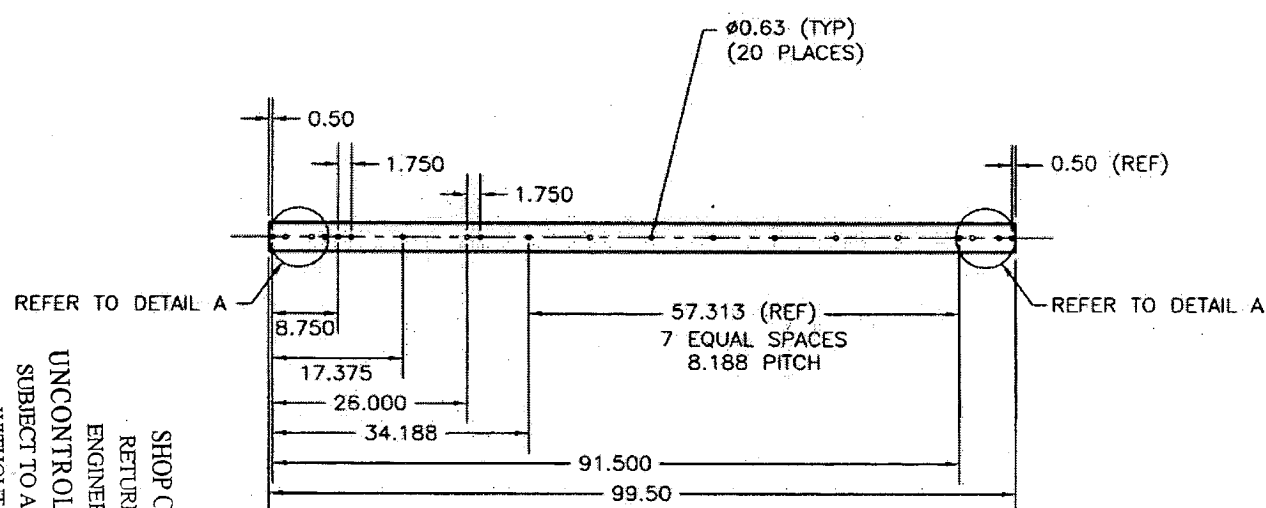
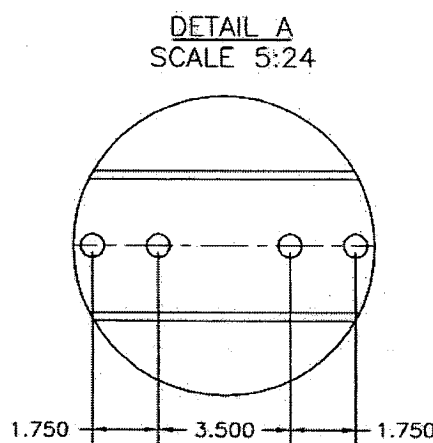
QA: N/C Closed: _____ Date: _____

DART



RELEASED
18.09.17 b3

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
CHECKED	APPROVED	DRAWING NO. D2596	SHEET 1 OF 1
DATE 98.09.14	TITLE 205 WEB	SCALE 1:24	
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEC 9097	



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 28025